

Sup Wed July 6

Work Order ID 71403

Monday, July 04, 2011 7:22:37 AM



Page 1

Item ID: D4006-3

Accept



Setup Start



Revision ID:

Item Name: Channel

Stop



Start Date: 7/4/2011 Start Qty: 200



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 200



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4006

A

100

0.00



Waterjet

FLOW CNC Waterjet

2024.063

Memo

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

0.00

B11-7-5

91

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B11-7-5

Work Order ID 71403

Monday, July 04, 2011 7:22:37 AM



Page 2

Item ID: D4006-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Channel

Start Date: 7/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #
Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

C'sink as per dwg

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

Sub 7/05

(9)

SB 11/07/05

(9)

EP 11/07/05

(9)

9 0 BL 11-7-6

Work Order ID 71403

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Page 3

Item ID: D4006-3

Accept

Revision ID:

Item Name: Channel

Start Date: 7/4/2011 Start Qty: 2.00

Required Date: 7/5/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 107

Memo

0.00

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

11 07 06 (9)

11/7/11

11/7/11

MF 11-07-06

Picklist Print

Monday, July 04, 2011 7:22:34 AM

Page 1

Work Order ID: 71403

Parent Item: D4006-3

Parent Item Name: Channel





Start Date: 7/4/2011

Required Date: 7/5/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 09.12.22 new Issue Prelim EC verified by:DD IPP Rev:B
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 		Purchased	No			100	sf	252.3800	0.0971	0.204421	1.		
2024-T3 .063 sheet											B11-7-5		

Location

Loc Qty

Loc Code

MAT022

252.38

117018

26.88

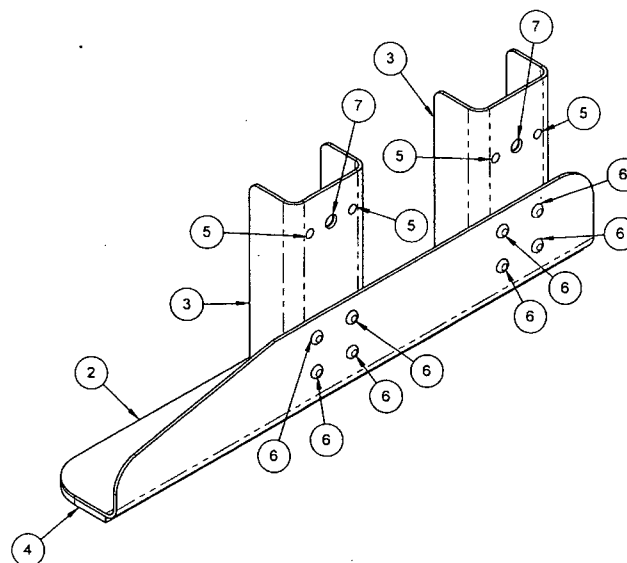
117392

225.5

117392

9

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4006-041	TANK TOP SUPPORT ASSEMBLY	JCA-M47-2-01
2	1	D4006-1	ANGLE	
3	2	D4006-3	CHANNEL	
4	1	D4006-5	FOAM	
5	4	MS20426AD3-4	RIVET	
6	8	MS20470AD4	RIVET	
7	2	MS21059-4	ANCHOR NUT	



D4006-041 TANK TOP SUPPORT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
BEFORE INSTALLATION OF D4006-5 FOAM AND MS21059-4 ANCHOR NUTS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4006-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs

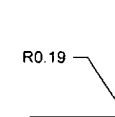
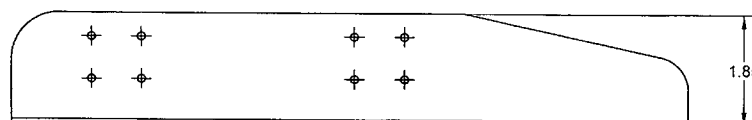
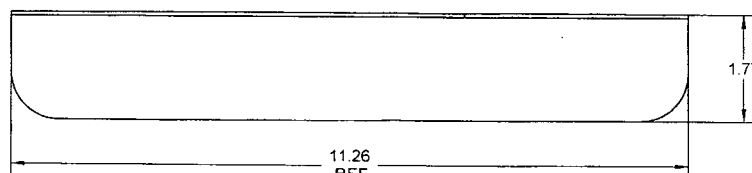
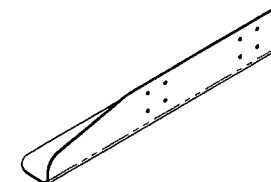
A	NEW ISSUE	10.02.05
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	10.02.05	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4006	REV. A SHEET 1 OF 6
TITLE UPPER RESTRAINT	SCALE NTS
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RELEASED
2010-05-05

WLO 71403

8	7	6	5	4	3	2	1
DART AEROSPACE PART NUMBER		JOHN CAMERON AVIATION PART NUMBER					
D4006-1		REF JCA-M47-2-01					



D4006-1 ANGLE

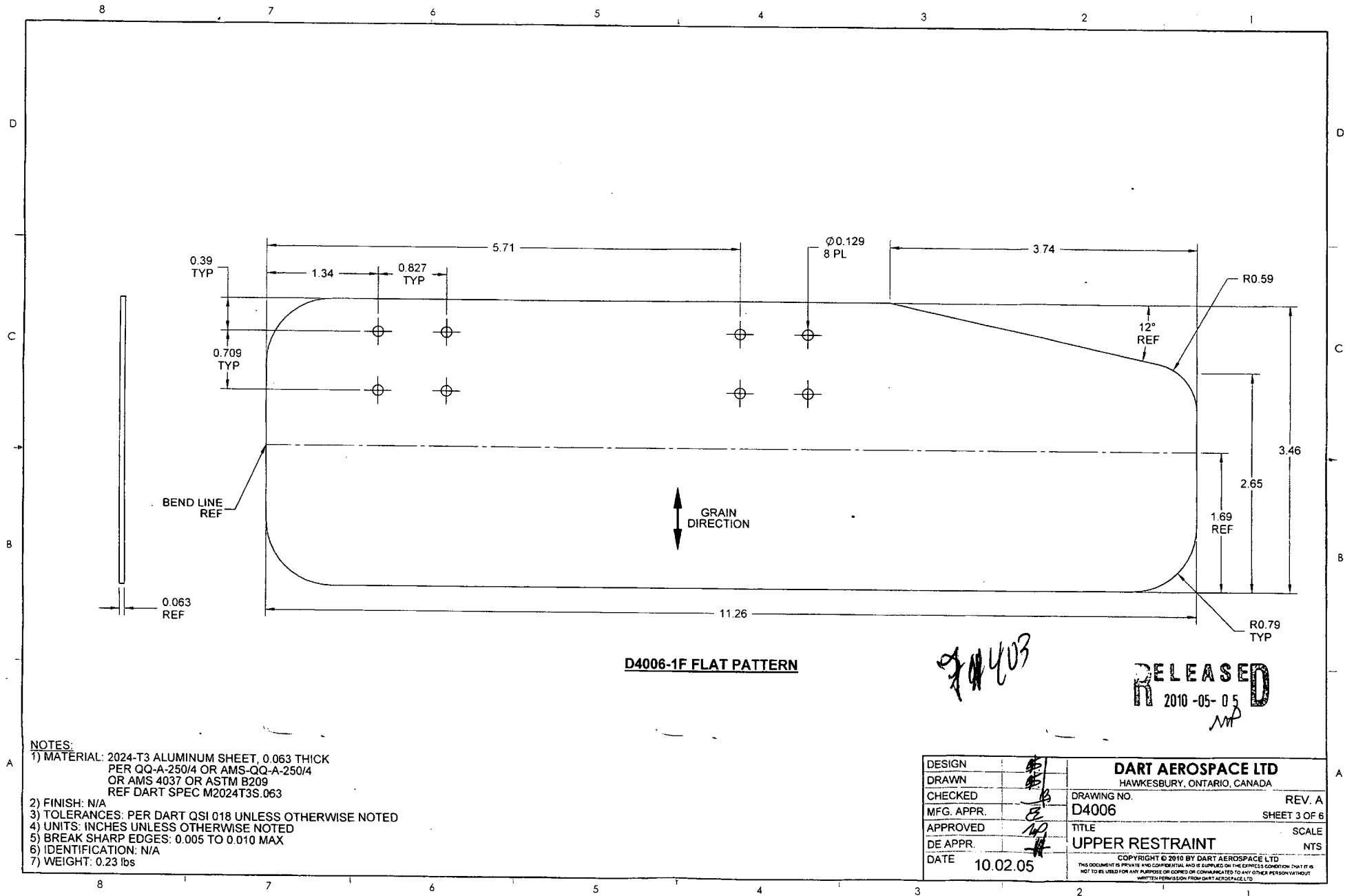
21403

RELEASED
2010-05-05
MM

NOTES:

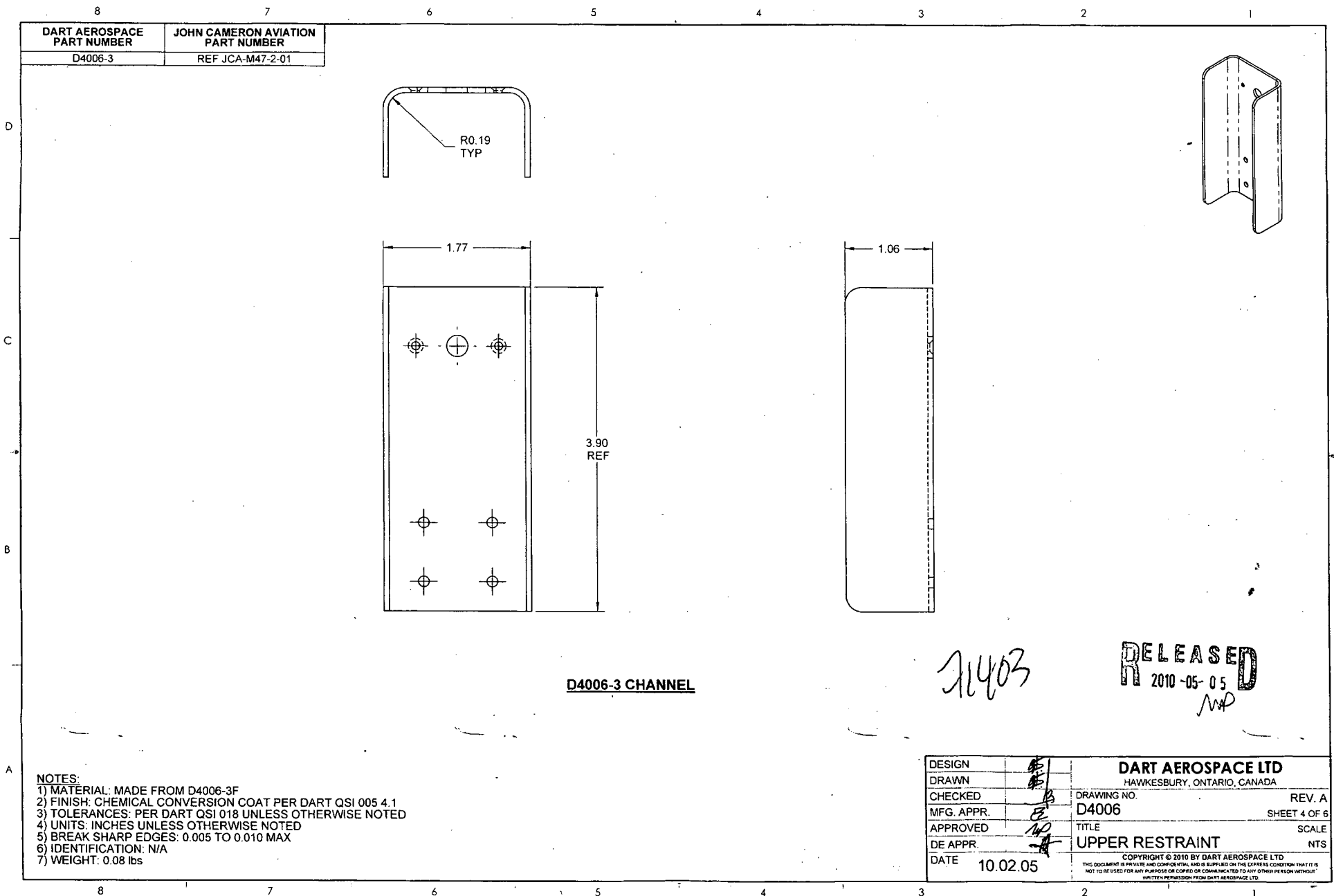
- 1) MATERIAL: MADE FROM D4006-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D4006	SHEET 2 OF 6
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DE APPR.		UPPER RESTRAINT	NTS
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NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
 PER QQ-A-250/4 OR AMS-QQ-A-250/4
 OR AMS 4037 OR ASTM B209
 REF DART SPEC M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs



D4006-3 CHANNEL

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8 7 6 5 4 3 2 1

D

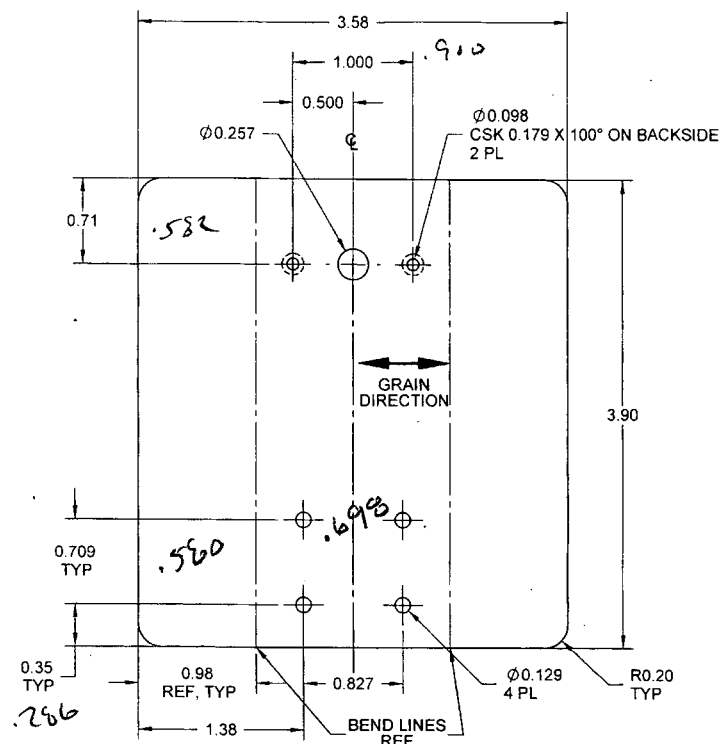
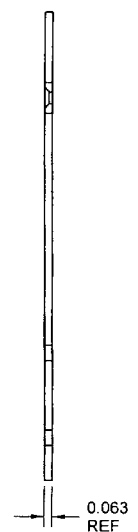
C

B

D

C

B



4003

D4006-3F FLAT PATTERN

RELEASED
2010-05-05
JAD

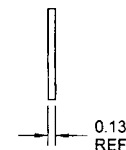
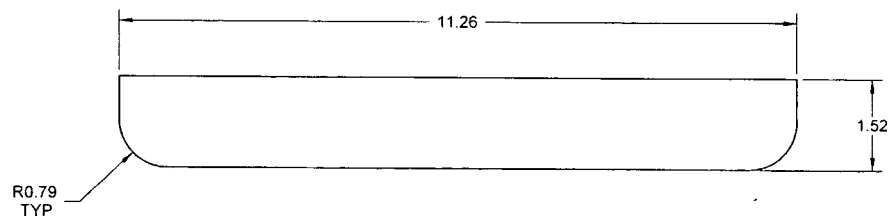
- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.08 lbs

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8 7 6 5 4 3 2 1

A

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4006-5	REF JCA-M47-2-01



D4006-5 FOAM

RELEASED
2010-05-05
md

NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET, 0.125 THICK
PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1
REF DART SPEC M-4111N-S.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.08 lbs

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MFG. APPR.		REV. A
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